

## OA 61

**CATEGORY** FCAW Flux-Cored

**TYPE** High-alloyed tubular wire on a C-Cr-B-W-V carbide basis for extreme hard deposits on parts subject to strong mineral abrasion.

**APPLICATIONS** Rebuilding and or protecting wornout parts that faces extreme abrasion attack with medium impact.

**PROPERTIES** Very good wear resistance even at higher temperatures. The deposit gives already a very good hardness in the first layer. A buffer layer with OA 4370 or OA MnCr is recommended in case of sensible base material or old layers. Weldable without protective gas.

**CLASSIFICATION**

AWS	A 5.21:
EN ISO	14700: ~T Fe14
DIN	8555: MF 10-65-GZ

**SUITABLE FOR** 62 HRc hardfacing alloy for use in Cement, Mineral and brick industry: screws, decanters, earthmoving equipment, wear plates, dredger teeth, pumps etc.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	V	W	Cr	B
4.0	0.80	0.80	22.0	1.0

**ALL WELD METAL PROPERTIES**

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							62-64

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool
1.2	18-24	100-220	S-300 / Coil B-450 / Drum	15 / 30 / 300
1.6	20-26	160-260	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.0	22-26	240-280	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.4	24-27	280-340	S-300 / Coil B-450 / Drum	15 / 30 / 300
2.8	25-28	320-400	S-300 / Coil B-450 / Drum	15 / 30 / 300

**REDRYING TEMPERATURE** 150°C / 24hr

**STICK OUT** 25-40 mm